

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029845**Date Inspected:** 11-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** USA Hoist**Location:** Crest Hill, IL.**CWI Name:** None present**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Elevator items**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) arrived at the USA Hoist production facility for the purpose of performing inspections of Tower Elevator items to the requirements CC0-085, Standard Specification and Special Provisions.

Welding performed and completed of Right-Handed Bearing & Roller Mounting Plates of Drawing# 914233, with both of these assemblies being completed this day. The welding was performed by Manola Lunas #B utilizing E71T-1 .045" diameter FCAW-G electrode as per AWS A5.20 and the approved WPS# FCAW3210. The shielding gas used was a mix of Argon@75%/CO2@25% with a flow rate of 38CFH. The welds performed of these completed members appear to meet the requirements of the contract documents.

Welding continued in-progress of mounting plates and gear-rack mounting discs of Tower Mast Poles. The welding was performed by Andres Luna, #1233, utilizing Kobe Steel 'Familiarc' E71T-1 .045" diameter FCAW-G wire as per AWS A5.20 and the approved WPS# FCAW3210. The shielding gas used was mix of Argon@75%/CO2@25% with a flow rate of 36CFH.

The re-galvanized Elevator Landing angle sample was received back to USA Hoist from MW Galvanizing. This QAI observed it's surface and found it to generally meet the requirements of the contract documents. This QAI witnessed the thickness measurements being taken by Tim Moran. All the readings ranged 5.9 and 11.0 mils (.0059" to .011") which exceeds the minimum requirement. Received a Certificate of Compliance from USA Hoist for this item and generated a Green-Tag package for Lot# 360-014-13 which was attached to the angle for release to Americana for Powder-coat painting.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

Project Manager Tim Moran was notified by this QAI that the re-galvanized sample angle had been Green-tagged for release, ready to send to Americana for powder-coating.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Morris, Monty
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Foerder, Mike
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QA Reviewer
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